

Work Order ID 101921

May-21-13 3:30:52 PM

101921

03955-23
B101921

Page 1

Item ID: D3955-23

03955-23

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Template

Stop

NS2

Start Date: 5/21/13

Start Qty: 12.00

12

Cust Item ID:

Required Date: 6/04/13

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: MLD

Date: 13-05-22 Tooling:

Run Start

NR1

QC:

Date: SPC (Y/N):

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3955 Dwg Rev: A Prog Rev: A								
6061.040	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110	QC	0.00							
Quality Control	Memo								

12 0 Ae 13.08.13

12 0 Ae 13.08.13

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS								
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other						
Part No. _____ NCR No. _____													
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector				
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup													
Other													
Process													
Supplier													
Training													
Unapproved													
FAULT CATEGORY													
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						<input type="checkbox"/> Ovalized <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Weld <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other			

Work Order ID 101921

May-21-13 3:30:52 PM

101921

Page 2

Item ID: D3955-23

Accept

Revision ID:

Item Name: Template

Start Date: 5/21/13 Start Qty: 12.00

12

Required Date: 6/04/13 Req'd Qty: 12.00

12

Reference:

Approvals: Process Plan:

Date: Tooling:

QC:

Date: SPC (Y/N):

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

120

QC8- Inspect parts - second check

0.00

120

QC

Quality Control

Memo

0.00

13.8.

130

Identify as per dwg & Stock Location: STO79

0.00

130

Packaging

Packaging

Memo

0.00

140

QC21- Final inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Run Start

NR1

Stop

NR2Tool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

10

12x

M.10.13-08-13

M.15.13-08-14

G(13-8-14)

NCR: Yes / No

DQA: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order:				DISPOSITION		AGAINST DEPARTMENT/PROCESS									
				Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering							
				Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality							
				Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>							
				Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>								
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector					
Doc/Data															
Equip/Tooling															
Operator															
Material															
Setup															
Other															
Process															
Supplier															
Training															
Unapproved															
FAULT CATEGORY															
Landing Gear				General											
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions							<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge			<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	
														<input type="checkbox"/> Other	

Picklist Print

May-21-13 3:30:55 PM

Page 1

Work Order ID: 101921

101921
D3955-23

Parent Item: D3955-23

Parent Item Name: Template

Start Date: 5/21/13

Start Qty: 12.00

Required Date: 6/04/13

Required Qty: 12.00

Comments: IPP RevA: New issue ID verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No				sf	672.2756		5.004632			

M6061T6S 040

6061-T6 .040 Sheet

Location

MAT021

121099

123874

Loc Qty

672.2756

273.7156

398.56

Loc Code

Ac
13.08.13

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS						
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio		<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other	

DART AEROSPACE LTD		Work Order: 101921
Description: Template		Part Number: D3955-23
Inspection Dwg: D3955	Rev: A	Page 1 of 1

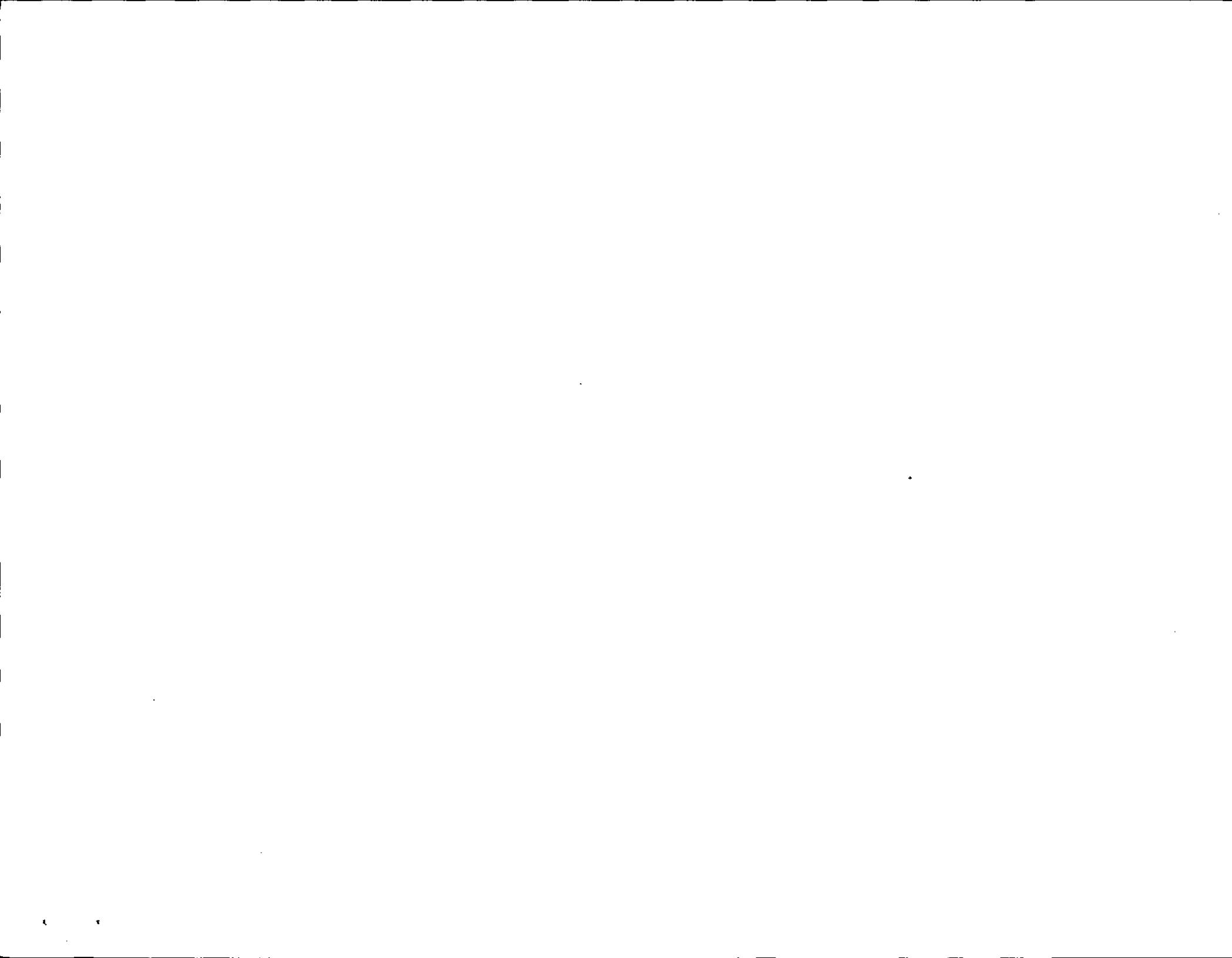
FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.100	-		V	Jkm-01
Ø0.129	+0.005/-0.001	.130	-		V	
0.750	+/-0.010	.750	-		V	
1.000	+/-0.010	1.000	-		V	
1.250	+/-0.010	1.250	-		V	
1.375	+/-0.010	1.375	-		V	
2.563	+/-0.010	2.563	-		V	
0.800	+/-0.010	.800	-			
1.500	+/-0.010	1.500	-		V	
2.250	+/-0.010	2.250	-		V	
2.750	+/-0.010	2.750	-		V	
3.250	+/-0.010	3.250	-		V	
5.000	+/-0.010	5.000	-		V	
6.500	+/-0.010	6.500	-		V	
7.500	+/-0.010	7.500	-		V	
8.000	+/-0.010	8.000	-		V	
8.500	+/-0.010	8.500	-		BT	Jkm-06
9.375	+/-0.010	9.375	-		BT	
9.625	+/-0.010	9.625	-		T	
10.600	+/-0.010	10.600	-		T	
11.13	+/-0.030	11.13	-		T	
0.040	+/-0.010	.038	-		V	

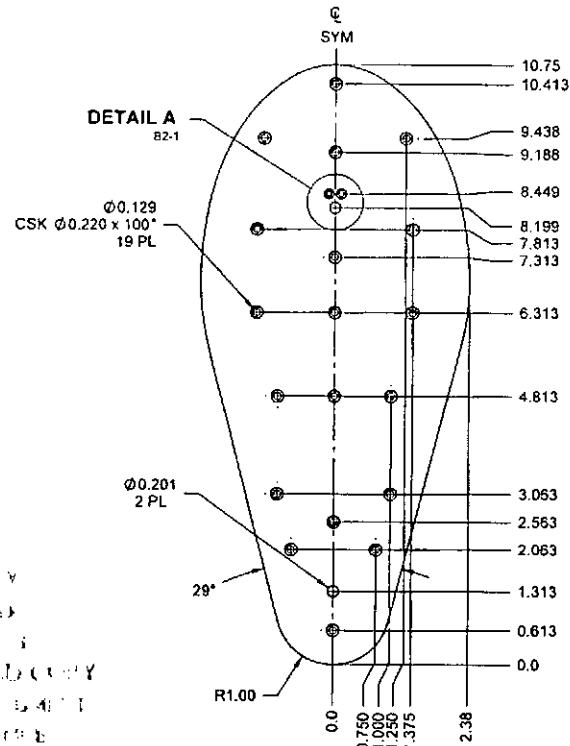
Measured by:	Ak	Audited by:	27	Prototype Approval:	N/A
Date:	13.08.13	Date:	13-8-13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	AS



8 7 6 5 4 3 2 1

0 D 1 2 3 4 5 6 7 8



SKIDTUBE
KIT ASSEMBLY
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO CHANGE

WITHOUT NOTICE

WORK ORDER

NO. 101921 MLJ

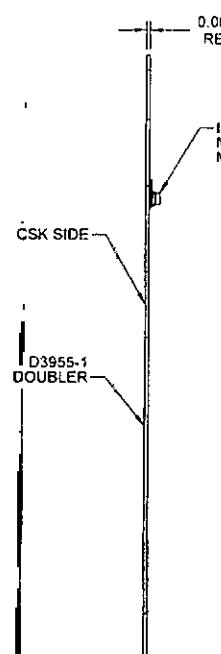
13-05-22

D3955-1 DOUBLER

D3955-1 NOTES:

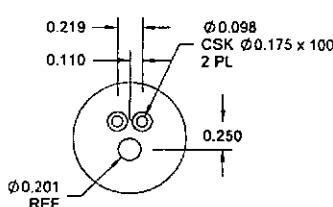
- 1) MATERIAL: 6061-T6 ALUMINUM, 0.063 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N "D3955-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

D3955-041 DOUBLER ASSEMBLY

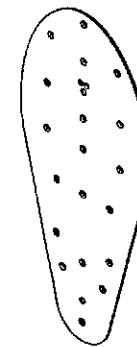


ITEM	QTY	P/N	DESCRIPTION
1	X	D3955-041	DOUBLER ASSY
2	1	D3955-1	DOUBLER
3	1	MS21086L3	NUT PLATE
4	2	MS20427M3-3	RIVET

INSTALL
MS21086L3 NUT PLATE
MS20427M3-3 RIVET, 2 PL



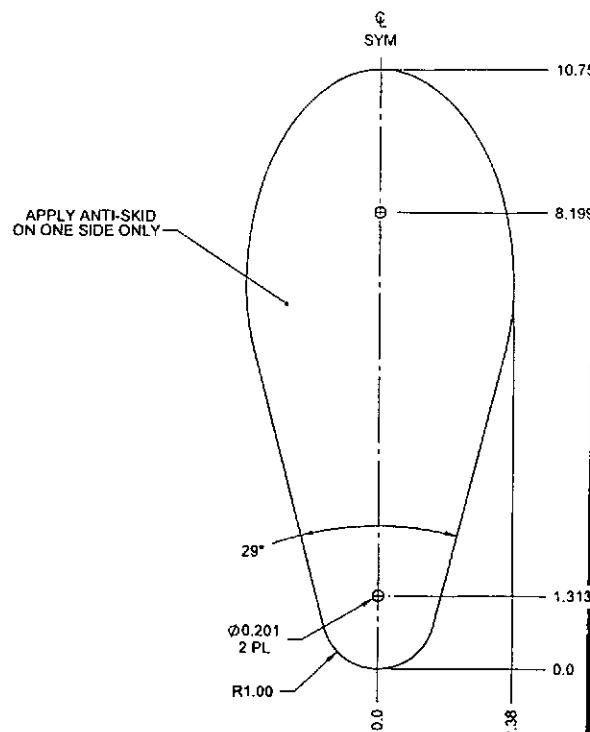
DETAIL A D7-1
SCALE 2X



RELEASED
07/22/2022

A	NEW ISSUE	RF	09.07.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A	DRAWING NO.	
MFG. APPR.	13	D3955	REV. A
APPROVED	MP	SHEET 1 OF 5	
DE APPR.	MP	TITLE	SCALE
DATE	09.07.21	SKIDTUBE TUNING KIT	NTS

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D3955-3 COVER PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.060 (16 GA) THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.64 lbs

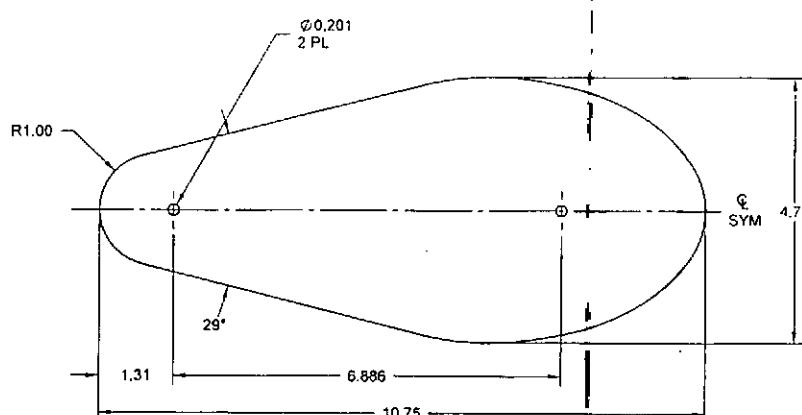
0.060 REF

RELEASED
(07/07/2021)

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	S	REV. A	
MFG. APPR.		DRAWING NO.	
APPROVED	AM	D3955	REV. 2 OF 5
DE APPR.		TITLE	SCALE
		SKIDTUBE TUNING KIT	NTS
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101921



General Table			
P/N	T (in)	T (GA)	WEIGHT (lbs)
D3955-5	0.060	16	0.64
D3955-7	0.120	11	1.28

NOTES:

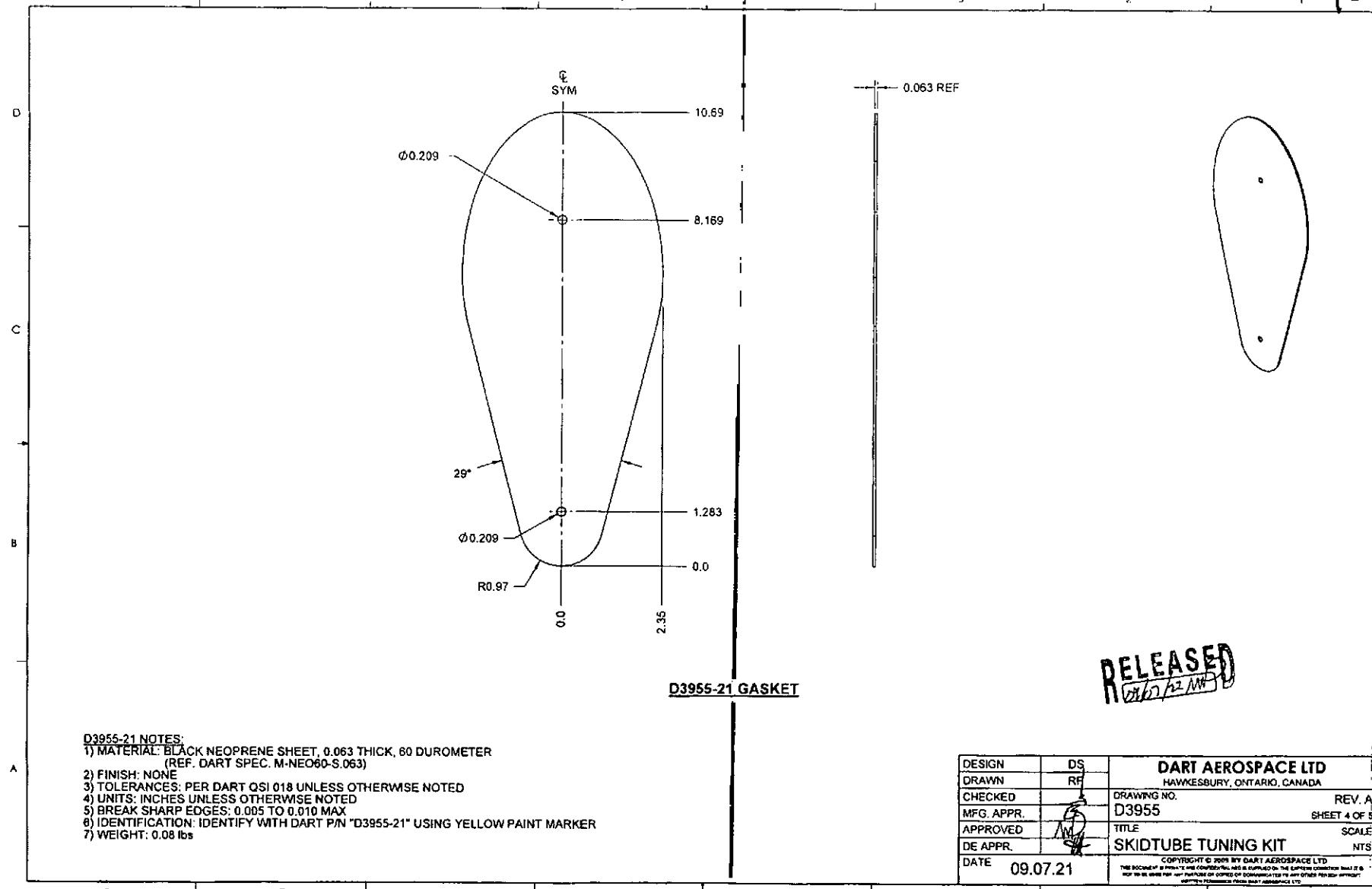
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, T (GA) THICK (REF. DART SPEC. M304ST'GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: SEE TABLE

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ED</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>ED</i>	D3955	SHEET 3 OF 5
APPROVED	<i>ED</i>	TITLE	SCALE
DE APPR.	<i>ED</i>	SKIDTUBE TUNING KIT	NTS
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RELEASED
6/6/2021 MD

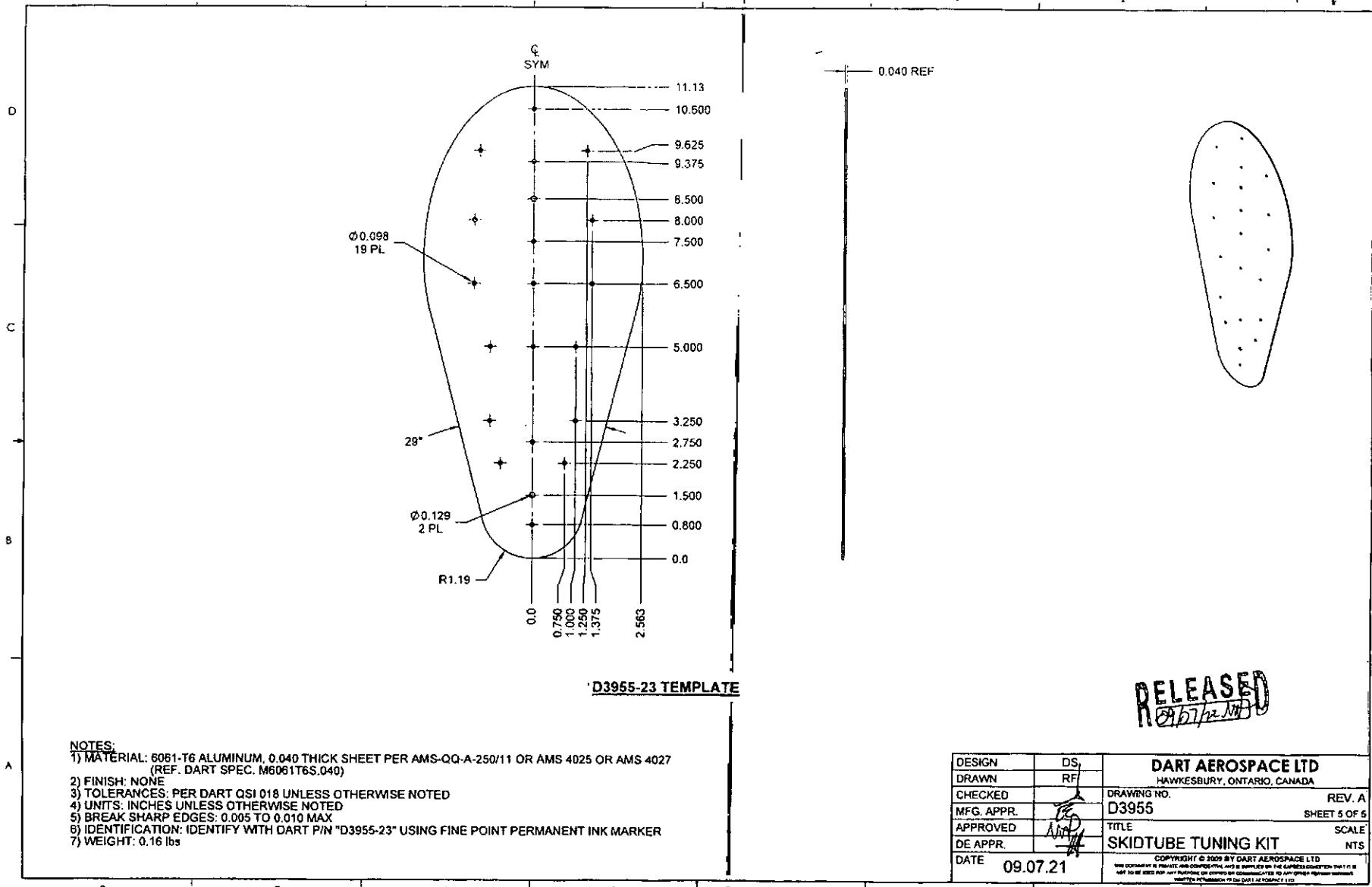


101921

RELEASED
09/07/21 MJD

DESIGN	DS	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. A
		DRAWING NO.
		D3955
		SHEET 4 OF 5
		TITLE
		SKIDTUBE TUNING KIT
		SCALE
		NTS
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CHECKED	<i>TS</i>	REV. A	
MFG. APPR.	<i>TS</i>	DRAWING NO.	D3955
APPROVED	<i>TS</i>	SHEET 5 OF 5	
DE APPR.	<i>TS</i>	TITLE	SKIDTUBE TUNING KIT
DATE	09.07.21	SCALE	NTS

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